

Date: Tuesday, 12/18/2007 10:54:52 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 36416	
Estimate Number : 12902	
P.O. Number :	Part Number : D350813
This Issue : 12/18/2007 S.O. No. :	Drawing Number : D3508 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/18/2007 Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33012	Material :
Written By :	Due Date : 1/20/2008 Qty: 10 Um: Each
Checked & Approved By : <u>07.12.18</u>	
Comment : Est Rev: A New Issue 07.06.12 EC	
Est Rev: B Rev C dwg 07-12-06 DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.1806 sf(s)/Unit Total : 1.8060 sf(s)  
 304 SS .038" THK  
 (M304S20GA)  
 Batch: 106702 HB 8-1-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3508  
 Dwg Rev: C HB 8-1-7  
 Prog Rev: C

2-Deburr if necessary HB 8-1-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508

SB 08/01/08 (10)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/10/11	#5.1	redo as per Desc. + <del>tan</del> Ready during *	FC	08/10/11	(9)	N/A A.	08/10/11 A.	
08/10/11	#5.3	<del>QC #5</del> QC #5	PD	08-01-11	9	N/A A.	N/A A.	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36416

Part Number: D350813

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28/01/11 (92)

7.0

POWDER COATING

POWDER COATING



M106442



(9X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m.d 08/01/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(9)

Comment: INSPECT POWDER COAT

BR 08-01-18

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 497

5/1/21 SD (9X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



5b (LF) Welding - weld hard surface per drawing D3508 Rev C  
Qty A/R Descr 20593 hardfacing B/N M106390

(P+O)

FC 08/01/11 (9)

SC QC9 PD 08-01-11

2008/1/21

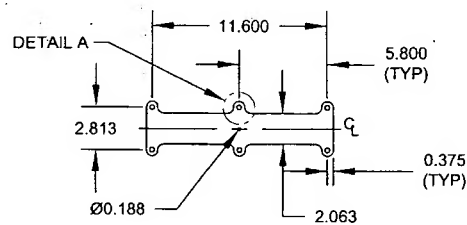
# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

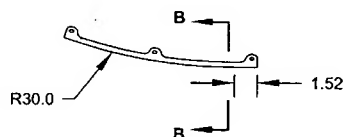
Part No: D3508-13 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: AS Date: 08-01-23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 36416		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-01-11	56	use 1 to make jig - scrap part	AS1042	<del>AS DT8988. Used for line location on wearplate to weld. I.D</del> I.D wearplate AS DT8988. Used for line location on wearplate to weld. I.D welding jig AS DT8989.	FC 08/01/01	08-01-22	AS1042	08-01-22

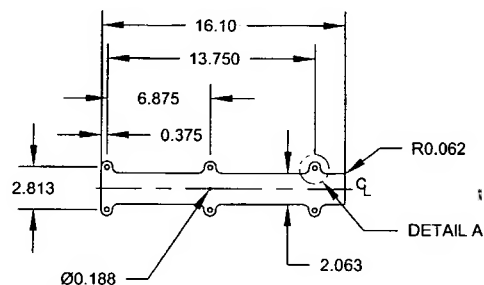
NOTE: Date & initial all entries



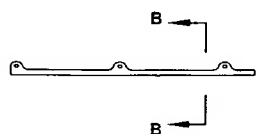
**D3508-1 FLAT PATTERN**



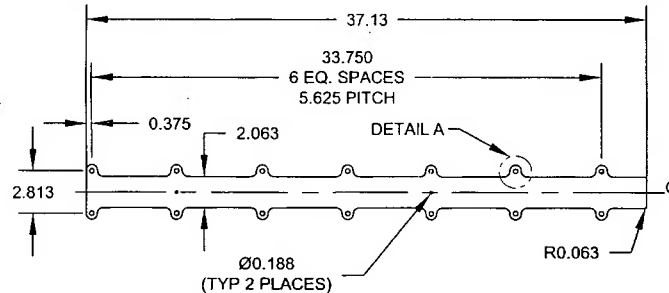
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(MAKE FROM D3508-1F)



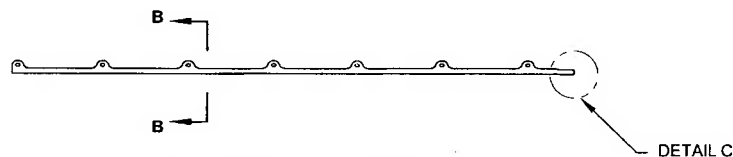
**D3508-7F FLAT PATTERN**



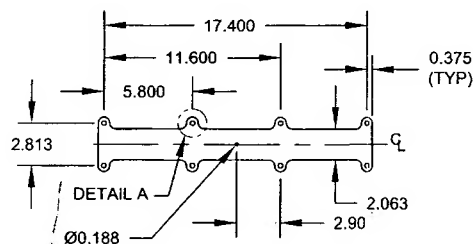
**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



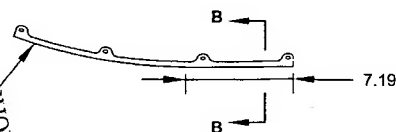
**D3508-3 FLAT PATTERN**



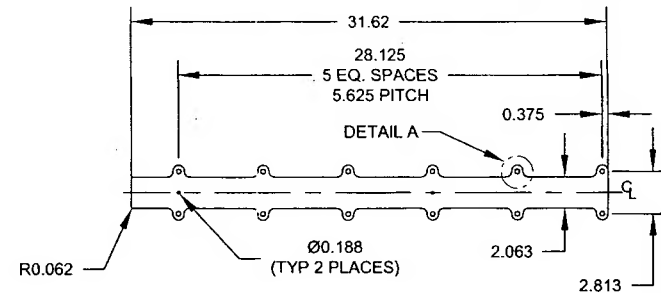
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



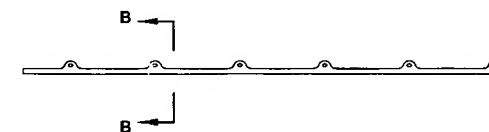
**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)



**D3508-5 FLAT PATTERN**



**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

**RELEASED**  
07-11-16

C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

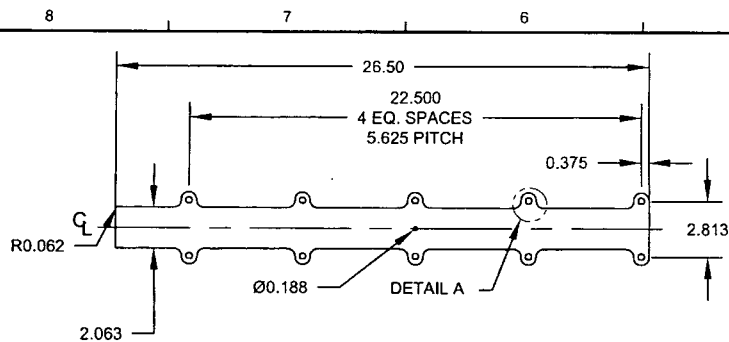
**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3508  
REV. C  
SHEET 1 OF 2

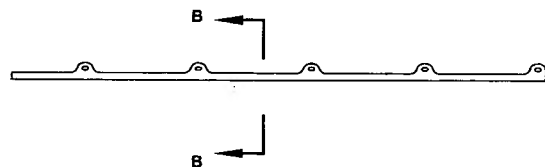
TITLE WEARPLATE  
SCALE 1:8

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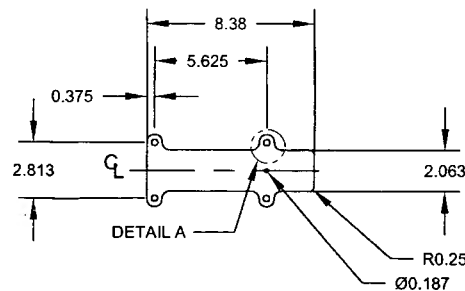
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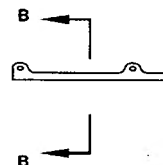
**D3508-11F FLAT PATTERN**



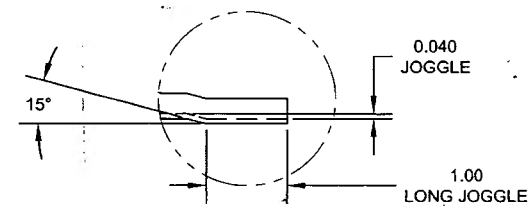
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



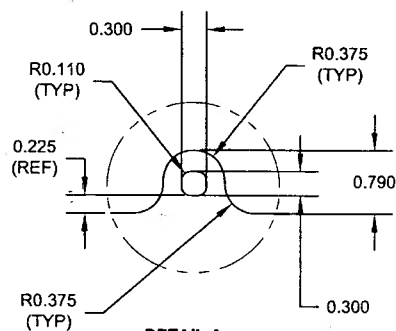
**D3508-13F FLAT PATTERN**



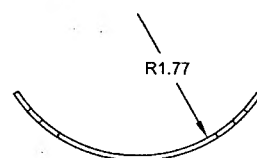
**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



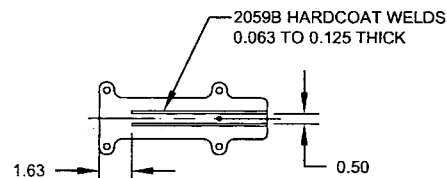
**DETAIL C**  
(SCALE 1:2)



**DETAIL A**  
(SCALE 2:3)



**SECTION B-B**  
(SCALE 2:3)



**D3508-13 WELDING DETAIL**

RELEASED  
07-11-15

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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